

Date: Thursday, 09/10/2008 10:20:50 AM
 User: Julie Lecocq

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: SEAT SUPPORT ASSEMBLY, RH
Job Number	: 42522		
Estimate Number	: 13329		
P.O. Number	:	Part Number	: D3784044
This Issue	: 09/10/2008 S.O. No. :	Drawing Number	: D3784 REV B
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 42521	Material	:
Written By	:	Due Date	: 25/10/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>JUL 08 10 09</u>		
Comment	: Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3763044	End Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 End Fitting Assembly, RH
 batch: B 40684

SB 08/10/15 (3)

3.0	D37701	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Tube
 batch: B 40978

SB

4.0	D37703	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Tube
 batch: B 40979

SB

5.0	D3763041	End Fitting Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 End Fitting Assembly
 batch: B 40952

SB 08/10/15 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 09/10/2008 10:20:50 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: SEAT SUPPORT ASSEMBLY, RH

Job Number: 42522

Part Number: D3784044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	MS21042L3	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M 108701

(10)

N 105031

(2)

SB

7.0	AN960JD10L	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: N 105793

(or NAS1149D0332J) batch:

SB

8.0	AN52510R20	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M 108559

SB 08/10/15 (3)

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3784

****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented down****

****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented forward****

SB 08/10/15 (3)

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 08/10/15 (3)

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: ST 257

SB 08/10/16 (3)

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/10/17

Job Completion



MF 08-10-16

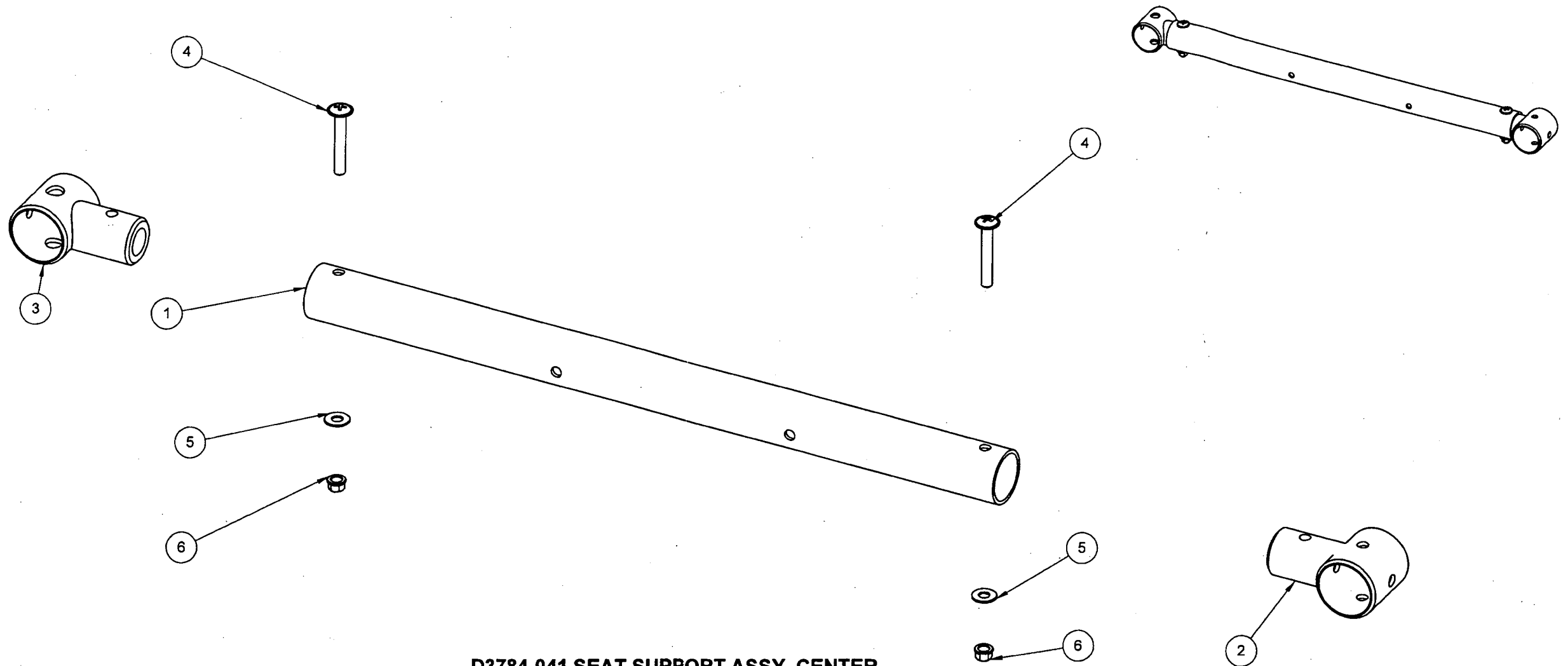
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

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NOTES:

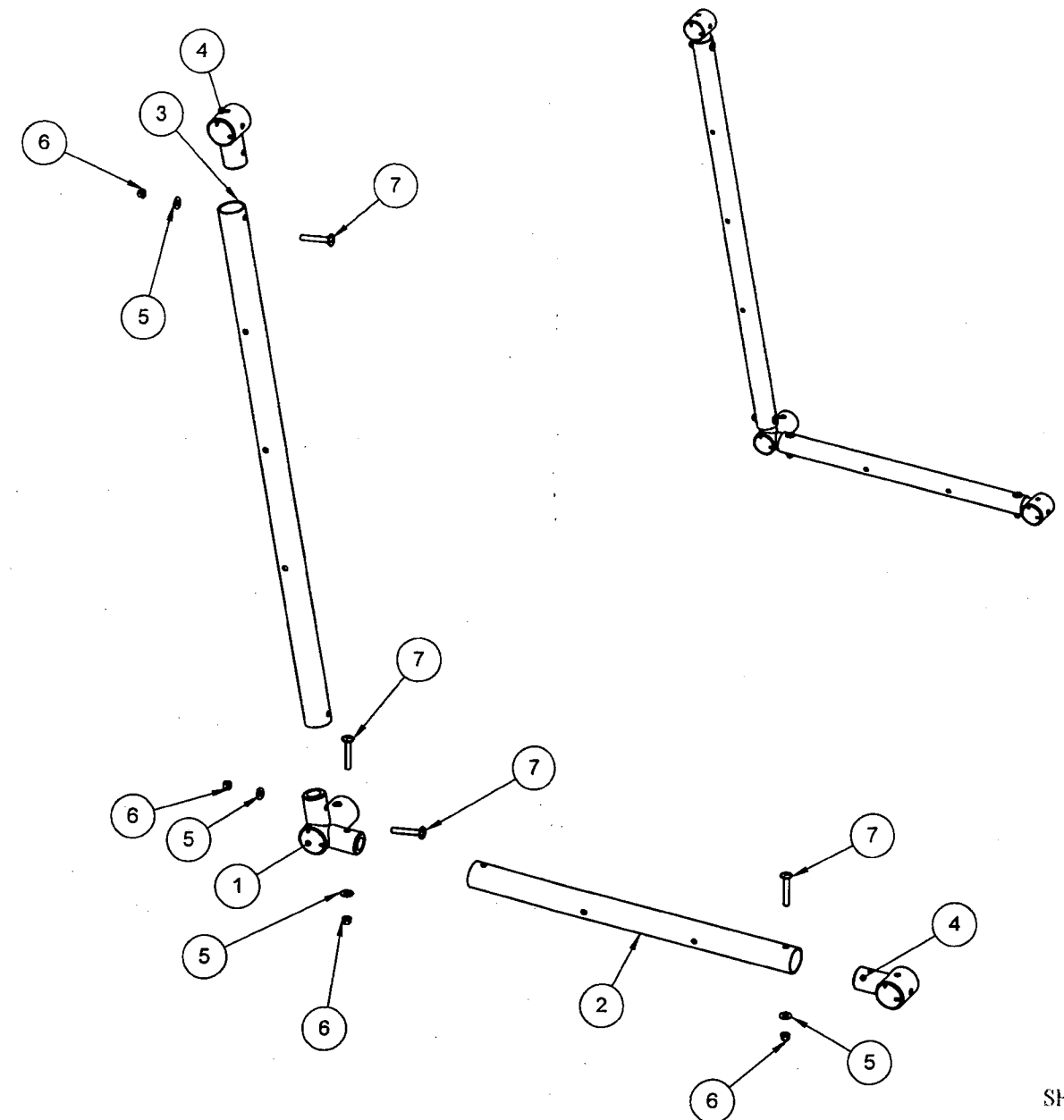
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
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WORK ORDER
NO. 12522

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4



D3784-043 SEAT SUPPORT ASSY, LH

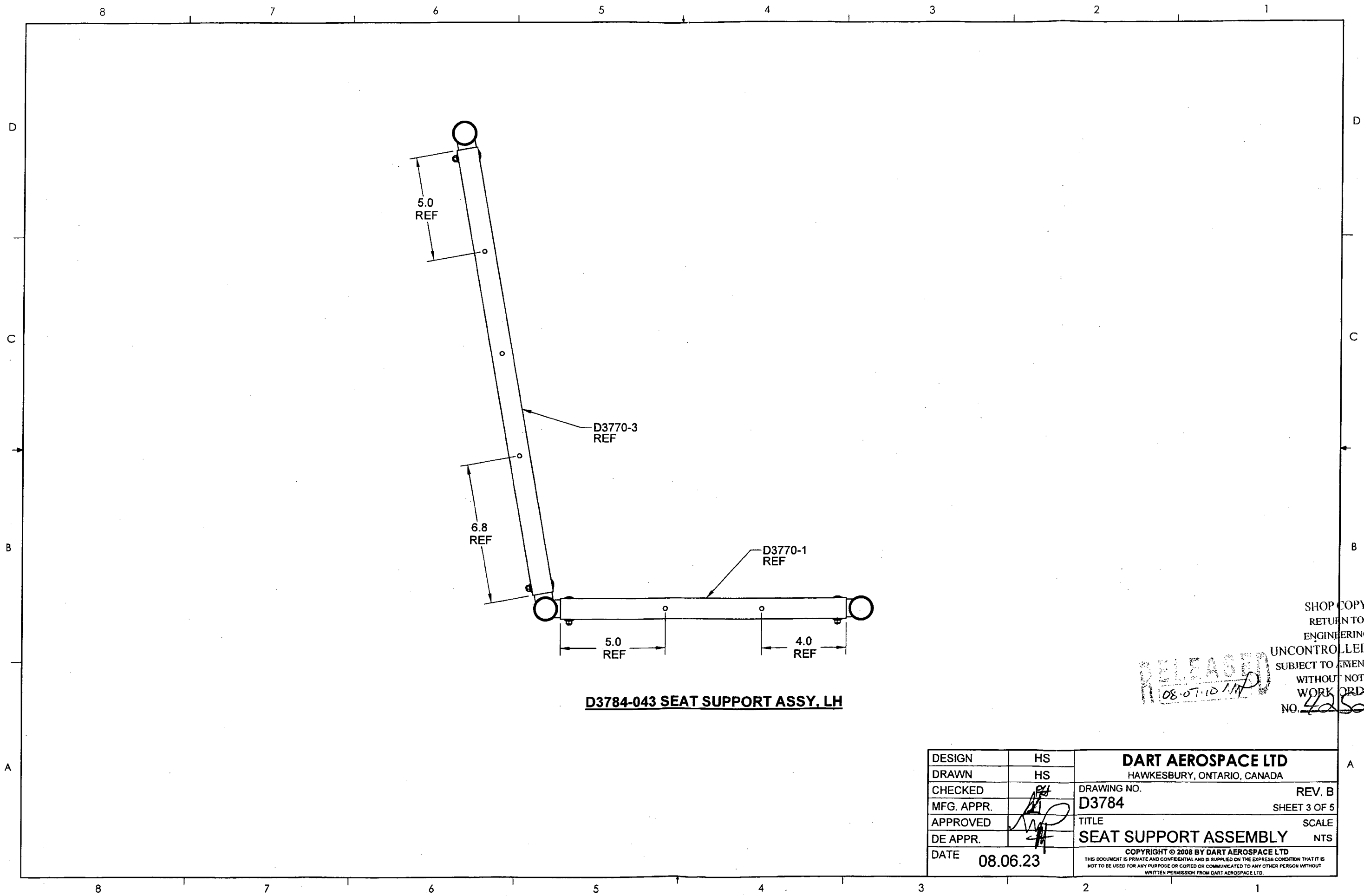
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

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MFG. APPR.	<i>MA</i>	D3784	SHEET 2 OF 5
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NO. 42522

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08-07-10

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MFG. APPR.	<i>[Signature]</i>	D3784	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

D

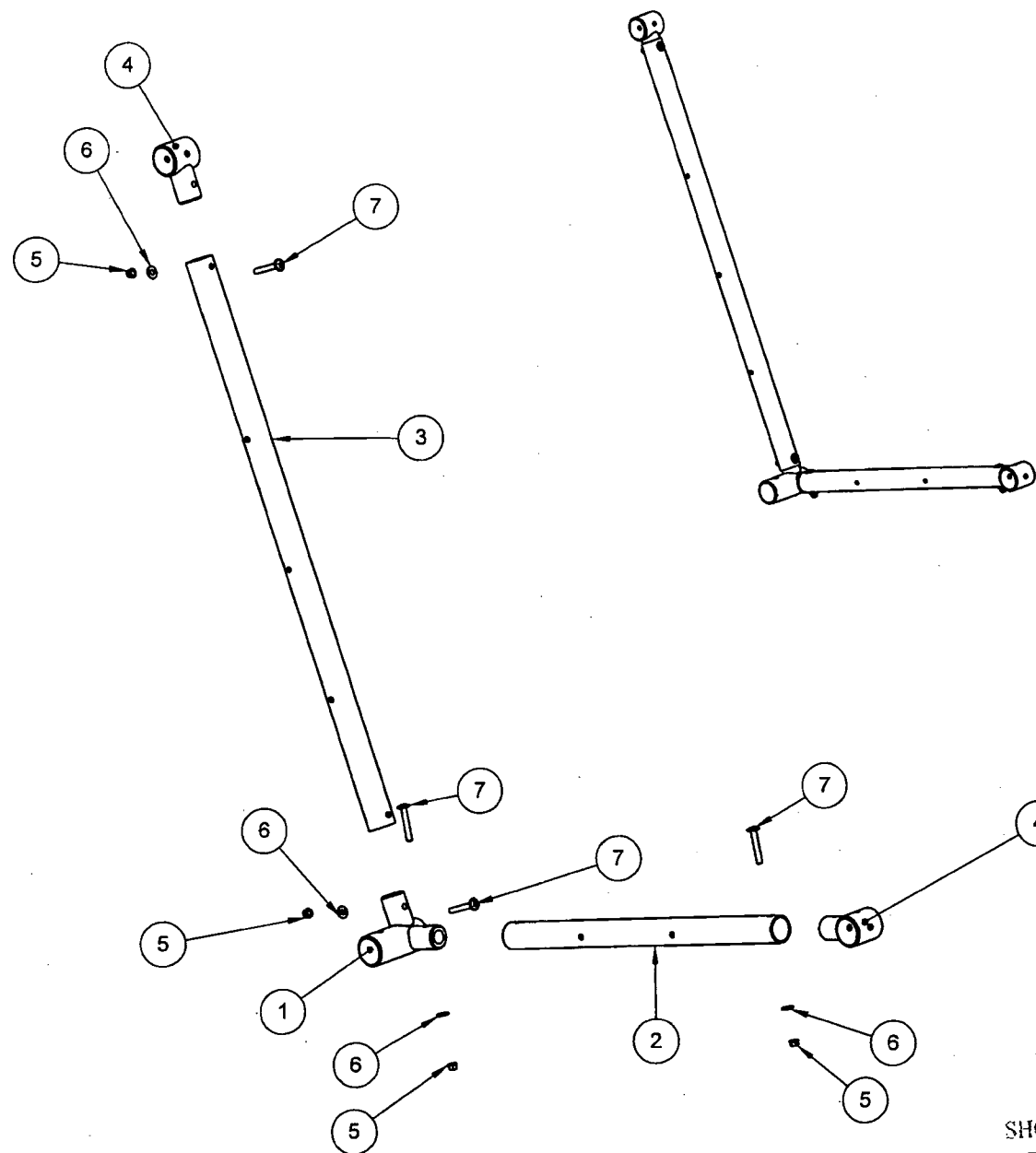
C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

△B
△B
△B



D3784-044 SEAT SUPPORT ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

8 7 6 5 4 3 2 1

D

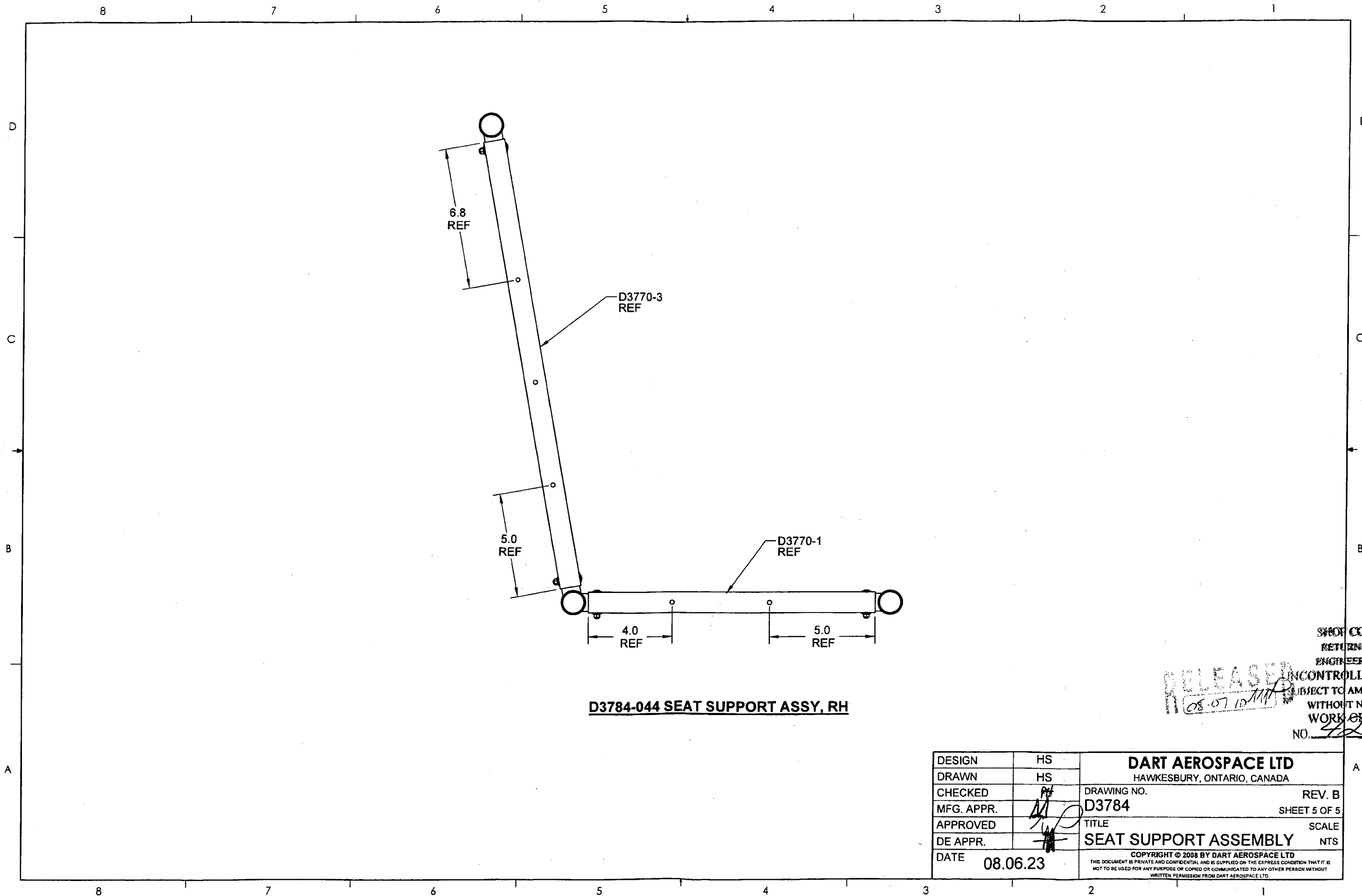
C

B

A

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APPROVED	PH	TITLE SEAT SUPPORT ASSEMBLY SCALE NTS
DE APPR.	PH	
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